0.00

0.00

13/05/04

120

OC

120

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

									DQA:	Date	e: `	
NCR: Ye	es / No			WORK ORDER NON-C	CON	FORN	ANCE / UPDAT		QA Closed:	Date	e:	
Work Order				 DISPOSITION				AGAINST DE				
Part No	D			 Rework Scrap Use-as-is Work Order Update		N Therm	Machining S noforming I	rosstube mall Fab Finishing omposite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root Cause	Date	Step	Qty	ption of work order update or Non-conformance		nitial ef Eng	Action Description	on	Sign & Date	Verification	QC Inspector	
quip/Tooling Operator Material Setup Other Process Supplier Training Juapproved												
					AULT	CATE	GORY					
Landin	g Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W Turning S	Crimped at n Strip in n Bend Vaves in E	Tube	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instructi Mainte Mislabe Misread Offset Out of C	on incomplete ions incomplete/Uncle nance led	ear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Wave/Tw			Folio		Outside Dimensions						

H:/FORMS/Quality_Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Work Order ID 100721

Tuesday, April 30, 2013 11:24:15 AM

100721

Item ID: Revision ID:

D3196-1

Item Name: Bar

Required Date: 5/7/2013

Start Date:

4/30/2013

Start Oty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date:

Tooling:

Accept

SPC (Y/N):

Date: Date:

N900040100

Run

Setup Start

Stop

Start

Sequence ID/ Work Center ID

130

130

QC

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/

0.00

Run Hours 0.00

Tool ID

FX13/05/04

Plan Tool # Code

Accept Qty

6

Reject Qty

Reject Number

Insp. Stamp

Quality Control

0.00

140 HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

6 1h 3-5-6

150

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150 Powdercoat

Powder Coating

Memo

START TIME:

0.00

OVEN TEMPERATURE:

FINISH TIME:

3200F

6 Kp M-f 13/05/07

migzapp

											DQA:	Date	e:
NCR: Y	es / f	No				WORK ORDER NON-	COI	VFOR	MANCE / UPD	DATE	0.4.61	D-4	
							-				QA Closed:	Date	2:
Work Orde	į					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	'` 					Rework	٦l		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	О.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					•	Use-as-is]	Thern	noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	lo					Work Order Update]		Large Fab	Composite]	Supplier	
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Cause loc/Data	Da	te	steb	Qty		or Non-comormance	1	iei ciig	Descri	iption	Date	Verification	QC IIISPECTOI
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	Bend	ing			L	Bend		Grain		L	Ovalized	L	Pressure/Forced
ļ	Cent	re No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	<u> </u>	Temperature/Cure
	Cracl		•		ļ	Broken/Damaged	<u> </u>	4	on Incomplete		Part Incorred	<u> </u>	Weld
			Crimped		<u> </u>	Burrs	_	4	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
· .	Cuffs	;			ļ	Contamination	\perp	Mainte		<u> </u>	Part Moved		
	_	Trea				Countersink	Mislabeled Positioned Wrong					¬	
			Strip in	Tube		Cut Too Short	<u> </u>	Misread			Power Loss/:	Surge	Other -
			Bend		_	Drill Holes	-	Offset	Salth and a				
			aves in E		^າ	Drawing	\vdash	-{	Calibration				
	_	-	equence		<u> </u>	Finish	\vdash	1	Sequence				
	Wav	e/Twi	ist in Tub	oe e	1	Folio		J Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

120

Quality Control

Tuesday, April 30, 2013 11:24:15 AM Item ID: D3196-1 Accept *N900040100* Setup Start Revision ID: Item Name: Stop Bar Start Date: 4/30/2013 Start Qty: 6.00 Cust Item ID: Required Date: 5/7/2013 **Req'd Qty:** 6.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence 1D/ Operation Set Up/ Tool ID Tool# Plan Reject Accept Reject Work Center ID Description **Run Hours** Qty Code Qty Number 160 QC3- Inspect Part Finish 0.00 *160* 0.00 Memo Quality Control Identify as per dwg & Stock Location: \$757, 0.00 170 *170* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

13-5-13

Insp.

Stamp

13/5/13

MJ 13-05-13

NCR:	Yes	1	No
14011.	103	,	110

DQA: _____ Date: ____

NCR: Ye	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
								-		QA Closed:	Date:		
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Part No	o				Scrap]	M	1achining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	The		oforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR No	0				Work Order Update]	l	Large Fab	Composite	<u>]</u>	Supplier		
Root		T		Descri	ption of work order update	Initia	ı	Act	tion	Sign &	· · · · · · · · · · · · · · · · · · ·		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	Chief Eng Description			Date	Verification	QC Inspector	
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· Picklist Print

Tuesday, April 30, 2013 11:24:14 AM

Work Order ID:

100721

Parent Item:

D3196-1

Parent Item Name:

Bar

Start Date: 4/30/2013

Required Date: 5/7/2013

Page 1

Start Oty: 6.00

Required Oty: 6.00

								5.	art Qty. 0.00		Required	Qty. 0.00
Comments:	IPP Rev: A New	Issue 05-11-08	JLM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M6061T6B0.750X01.500 6061-T6 Bar .750 X 1.50		Purchased	No	·		100	ſ	31.4060	2.183	13.78736	8	(30503
				Location MAT049		<u>Loc Qtv</u> 31.4060302	Lo	c Code		\$ 89 0.50	•	
			ï	121 122		4.262668 3.1433622			ART			

24

122753

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.[_	Centre N	Centre Not Concentric to O/S BOM/Route						re		Over/Under	 	Temperature/Cure	
	Cracks				Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorred	ct	Weld	
[Crushed/	Crimped			Burrs	Ш	Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs			Ŀ	Contamination	Ш	Mainte	nance		Part Moved		·	
	Heat Trea	at		<u> </u>	Countersink	Ш	Mislabe	led		Positioned V	_	-	
	Inspectio	n Strip in	Tube	L	Cut Too Short	-	Misread	l		Power Loss/	Surge	Other	
	Ripples in	n Bend			Drill Holes	-	Offset						
	Torque V	Vaves in I	Extrusion	ր <u> </u> _	Drawing	1		Calibration					
	Turning S	equence			Finish	equence							

Outside Dimensions

DQA:

Date:

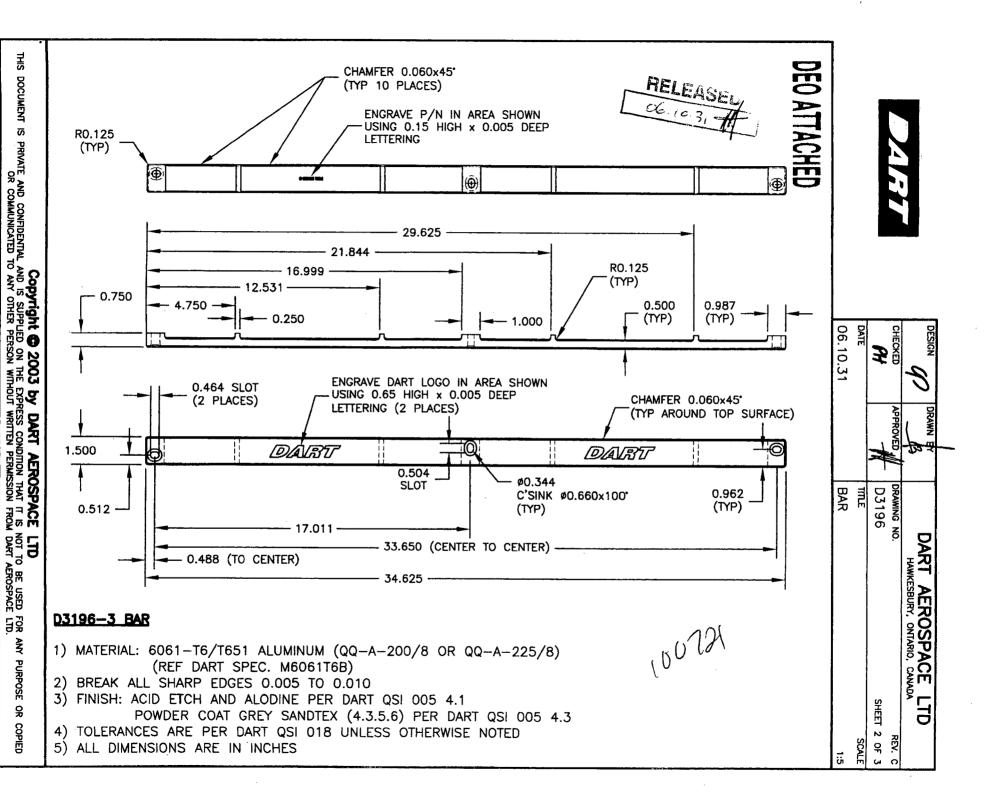
Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

NCR:	Yes	1	No
INCN.	162	,	INU

DQA: _____ Date: _____

NCR: Ye	es / No				WORK ORDER NON-	CON	FORM	MANCE / UP	DATE	QA Closed:	Date	
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					Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR No	D	<u> </u>			Work Order Update	╛┃		Large Fab	Composite	_	Supplier	
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-	Cuffs			L	Contamination	\vdash	Mainte		ļ	Part Moved		
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1	Inspectio		Tube	<u> </u>	Cut Too Short	$\boldsymbol{\vdash}$	Misread	l	L_	Power Loss/	Surge	Other
]_	Ripples in			<u> </u>	Drill Holes		Offset					· · · · · · · · · · · · · · · · · · ·
L	Torque W			۱	Drawing	-		Calibration				
L	Turning S			L	Finish			Sequence				
	Wave/Tw	vist in Tul	oe e		Folio	1 1	Outside	Dimensions		-		



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Part N					Rework Scrap Use-as-is		ſ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
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Root				Descri	ption of work order update		Initial	Act	ion		Sign &			
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	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	re		╝	Over/Under	tolerance		Temperature/Cure
	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		╛	Part Incorred	:t		Weld
	Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/U	Inclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		╛	Part Moved			
	Heat Tre	at			Countersink		Mislabe	led			Positioned W	Vrong		
[Inspection	n Strip in	Tube		Cut Too Short	Misread					Power Loss/S	Surge		Other
ľ	Ripples in	n Bend			Drill Holes	Offset								

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

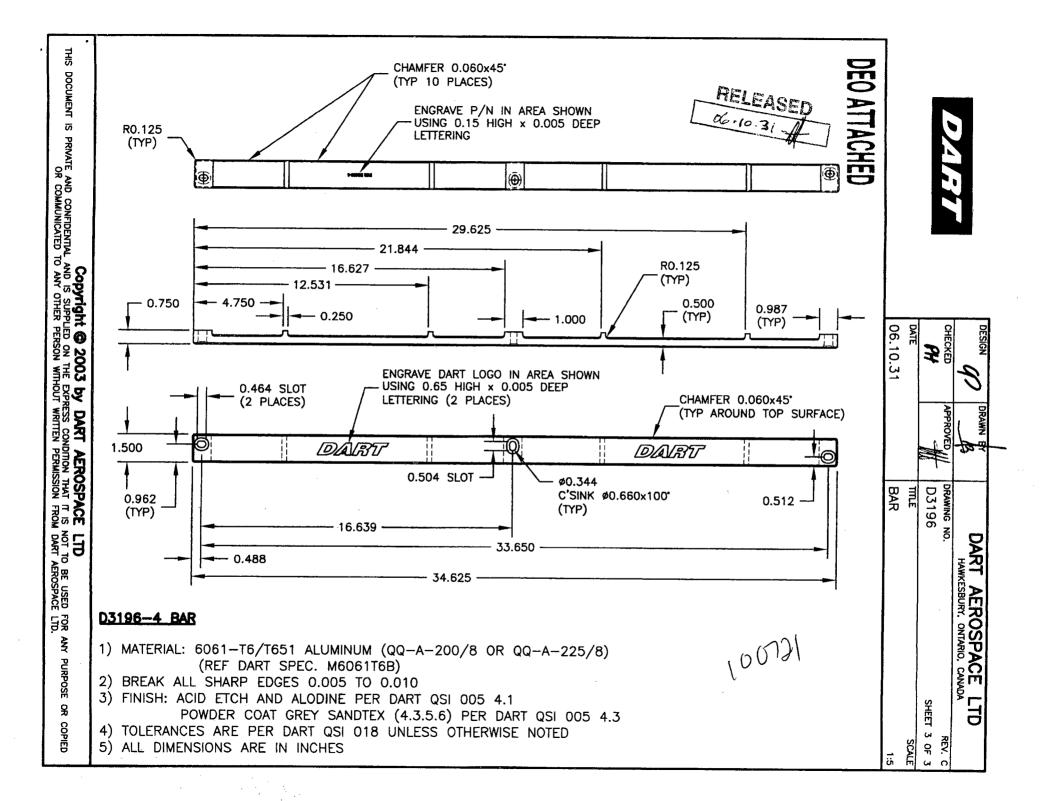
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



												DQA:	D	ate:	·
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									·			QA Closed:	D	ate:	
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Part N	do.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor	<u> </u>	Quality
1 4111	•••					Use-as-is	1 1		noforming	Finishing		-1	e/Packaging	-	Other
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Bending						Bend	Ш	Grain		_		Ovalized		<u> </u>	Pressure/Forced
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	⊢	racks				\boldsymbol{arphi} , \boldsymbol{arphi} \boldsymbol{arphi}			on Incomplete	<u> </u>	_	Part Incorred		\vdash	Weld
	$oldsymbol{oldsymbol{ o}}$	rushed/0	Crimped		<u> </u>	Burrs Instructions Incomplete/Unclear				Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	l Ici	uffs			1	Contamination Maintenance						Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

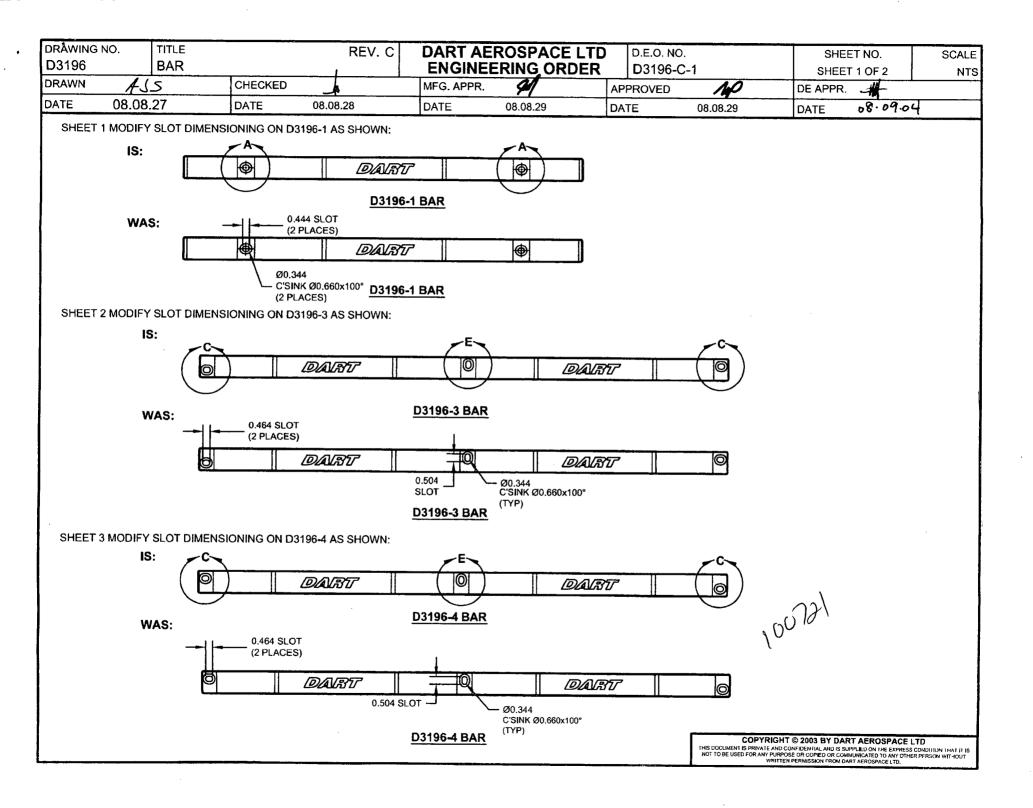
Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion



										DQA:	Date	e:
NCR:	res / No				WORK ORDER NON-	COV	IFORM	MANCE / UPDATE				
· · · · · · · · · · · · · · · · · · ·			,		_					QA Closed:	Date	2:
Work Orde	or.				DISPOSITION			AGAINS'	T DE	PARTMENT	PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fal noforming Finishing Large Fab Composite	b g	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
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	Bending			_	Bend	Ш	Grain		L	Ovalized		Pressure/Forced
	Centre I	Not Conce	ntric to	O/S	_BOM/Route	Hardware				Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete	L	Part Incorrec	t L	Weld
	Crushed	l/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mis	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance	L	Part Moved		
	Heat Tre	eat			Countersink		Mislabe	eled	Positioned W	rong/		

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Other

Power Loss/Surge

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

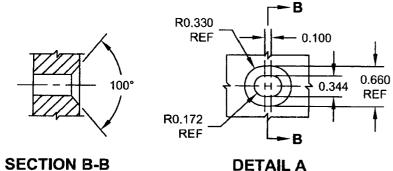
Drill Holes

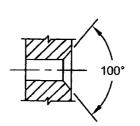
Drawing

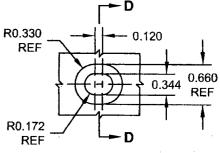
Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





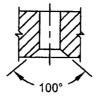




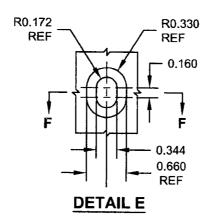
DETAIL A

SECTION D-D

DETAIL C



SECTION F-F





NOTE: THIS CHANGE HAS BEEN DONE TO CLARIFY SLOT DIMENSIONS ONLY. NO CHANGES HAVE BEEN MADE TO THE PARTS SEE NCR 08-051 FOR FURTHER INFORMATION ALL OTHER INFORMATION REMAINS UNCHANGED

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NCR:	/es	/ No				WORK ORDER NON-	COI	NFORM	//ANCE / UPDATE					¥.,
											QA Closed:	. D	ate:	
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Part I	- No					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					╡	Water Je d. Eng. Coor e/Packaging Supplie		Engineering Quality Other
Root					Descri	ption of work order update					Sign &			•
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	on	QC Inspector
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Operator	Ш								ı					
Material						•								
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Other	Щ						ı							
Process							1					•		
Supplier														•
Training	Ш											-		
Unapproved			<u> </u>		··-		<u></u>	T 64 T F	2001		<u> </u>			
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Landi						General		ار. د د			ا د داد م			D
	-	Bending				Bend	-	Grain			Ovalized	.	\vdash	Pressure/Forced
	\vdash	Centre No	ot Conce	ntric to (^{D/S} -	BOM/Route	\vdash	Hardwa		H	Over/Under		Н	Temperature/Cure
	Cracks Crushed/Crimped					Broken/Damaged	\vdash	-	on Incomplete	┝	Part Incorred		-	Weld
	-		Crimped		-	Burrs	-	-{	ions Incomplete/Unclear	┝	Part Lost/Mi	ssing	Ш	Wrong Stock Pulled
Cuffs						Contamination	\vdash	Mainte		\vdash	Part Moved			
	Н	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe		\vdash	Positioned V	-		Other
	\vdash	Inspectio		Tube	-	Cut Too Short	Misread			<u></u>	Power Loss/	Surge	Ш	Other
	igspace	Ripples ir			<u> </u>	Drill Holes	\vdash	Offset	S (1)					
1	1 1	Torque W	/aves in l	Extrusion	1 I	Drawing	1	IOut of C	Calibration					

Out of Sequence

Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	100721
Description: Bar	Part Number:	D3196-1
Inspection Dwg: D3196 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.094	+/-0.010	26,100			MTAPE	P40 -4
4.045	+/-0.010	4,046			VEL	Pr10 0)
18.003	+/-0.005	18,003			VERU	PHO-01
0.750	+/-0.005	. 749		-	14	
1.500	+/-0.010	1,505		,	٠.	••
Ø0.344	+0.006/-0.001	.345			1:	1.
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	.660	/		14	4
0.060 x 45°	+/-0.010 x 0.5°	.050			1.	1.
0.750	+/-0.010	. 755			٤.	1.
0.250	+/-0.010	. 241			£ (ic
3.495	+/-0.010	3,499	/		3 6	p
9.000	+/-0.010	9.005	/		• •	
16.844	+/-0.010	16,850			1.	
21.498	+/-0.010	21,503			()	
R0.125	+/-0.010	. 125	/		R G	
1.1 00	+/-0.010	1,101	/		VERN	PHD-01
R0.125	+/-0.010	. 125	/		RG	IND DI
0.444	+/-0.010	. મેપડ	/		V620	PUD-01

Measured by:	PO	Audited by:	FK	Prototype Approval:	N/A
Date:	13/05/04	Date:	13/05/07	Date:	N/A

Date	Change	Revised by App	roved
04.04.20	New Issue	KJ/RF	
06.10.24	Dwg Rev. updated	KJ/JLM	
07.03.21	Dimensions updated per Dwg rev. C	KJ/JLM A	B
	04.04.20 06.10.24	04.04.20 New Issue 06.10.24 Dwg Rev. updated	04.04.20 New Issue KJ/RF 06.10.24 Dwg Rev. updated KJ/JLM

NCR:	Yes	/ No

											DQA	Date	:	
NCR:	CR: Yes / No						WORK ORDER NON-CONFORMANCE / UPDATE							
						_					QA Closed	: Date	:	
Vork Ord	ar.						DISPOSITION			AGAINST (DEPARTMENT	/PROCESS		
OIR OIG							Rework Skid-tube Crosstube			Water Jet	Engineering			
Part I	No.						Scrap			Machining Small Fab		od. Eng. Coor.	Quality	
							Use-as-is			moforming Finishing	Rec/Sto	Rec/Store/Packaging Other Other		
NCR I	۷o.						Work Order Update Large Fab Composite				Supplier	j. []		
Root					Des	crip	otion of work order update		nitial	Action	Sign &			
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector	
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Landi	na (Gear			· · · · · · · · · · · · · · · · · · ·		General		CATE	, conti				
Lario		Bending					Bend		Grain		Ovalized	. [Pressure/Forced	
		Centre Not Concentric to O/S Cracks					BOM/Route		Hardwa	are	Over/Under	r tolerance	Temperature/Cure	
	\vdash						Broken/Damaged	Г	Inspect	ion Incomplete	Part Incorre	ect	Weld	
		Crushed/Crimped				Burrs	Instr		Instructions Incomplete/Unclear		lissing	Wrong Stock Pulled		
		Cuffs					Contamination		Maintenance		Part Moved			
		Heat Treat					Countersink		Mislabeled		Positioned Wrong		_	
		Inspection Strip in Tube					Cut Too Short		Misread		Power Loss	/Surge	Other	
	Ripples in Bend					Drill Holes		Offset						
	Torque Waves in Extrusion				Drawing		Out of	Calibration						
		Turning S	equence			_	Finish		4	Sequence	• • •			
	Wave/Twist in Tube						Folio	1	Outside	e Dimensions				